
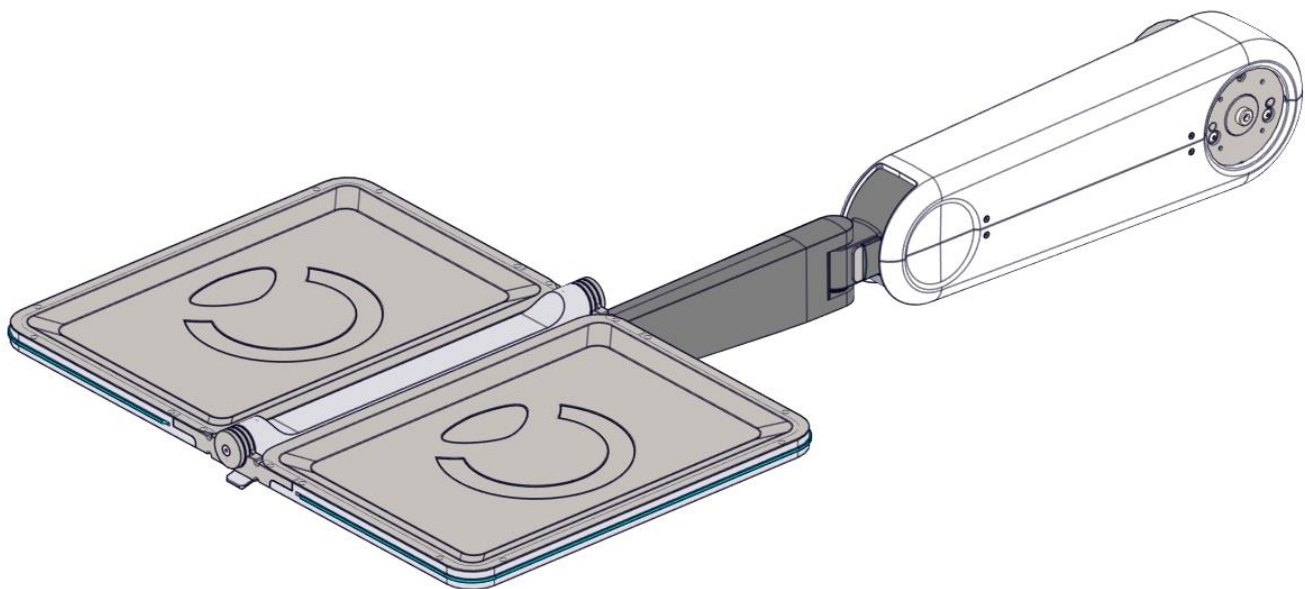


D.M.R. WORK INSTRUCTION			
Article number:	23610600		
Description:	MODULE MAYO ARM		
Revision:	E	Status:	Released






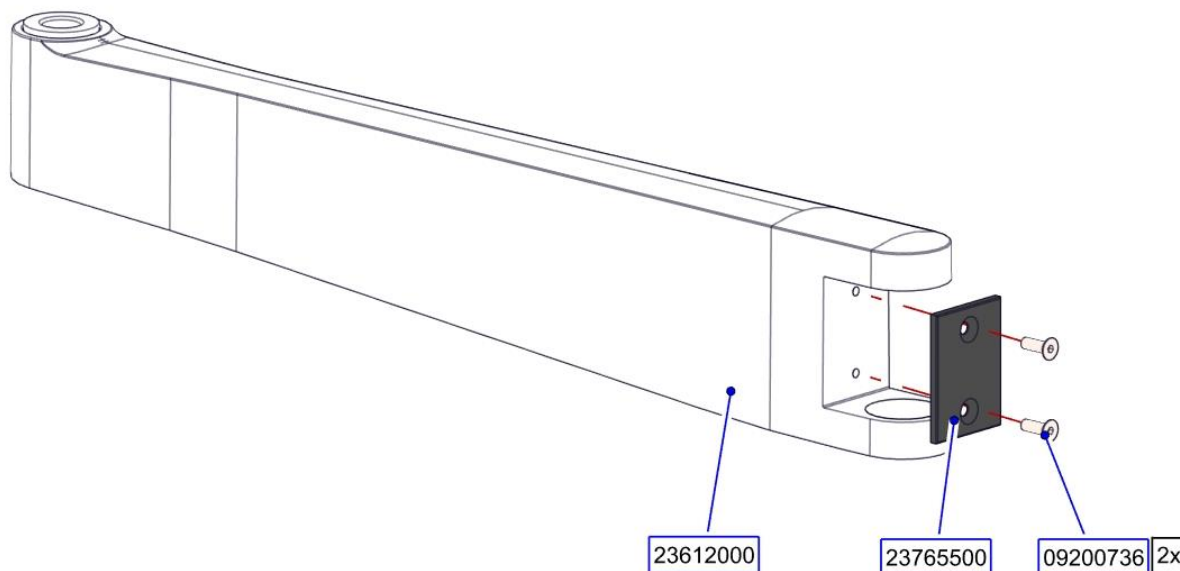
R&D Approved By: T.B.D.	Date: T.B.D.	Marketing Approved By: T.B.D.	Date: T.B.D.	QA Authorized By: T.B.D.	Date: T.B.D.
Production Approved By: T.B.D.	Date: T.B.D.	Global Service Approved By: T.B.D.	Date: T.B.D.	Created By: Peter Moree	Date: 18-02-2019
MNPD/MSE Approved By: T.B.D.	Date: T.B.D.	RA Approved By: T.B.D.	Date: T.B.D.	Page: 1 of 14	
				Template: DF 7.3/01/16, version 03	

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D.M.R. WORK INSTRUCTION			
Article number:	23610600		
Description:	MODULE MAYO ARM		
Revision:	E	Status:	Released



Stap 1




Part Number	Description	Qty	Length
09200736	SCHROEF M4*10 V.K/B DIN7991	2	
23612000	SUBSAM MAYO FORE ARM	1	
23765500	FORE ARM BUFFER	1	

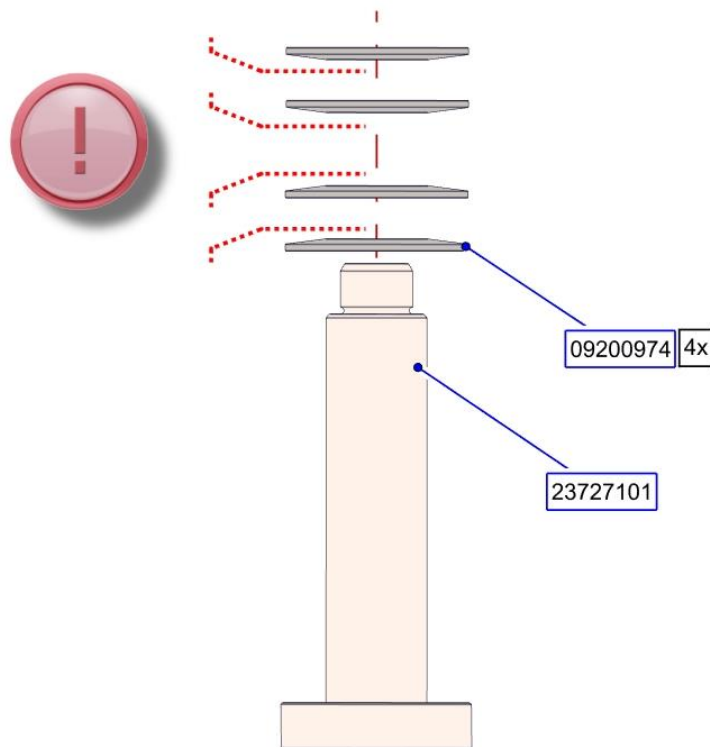
R&D Approved By: T.B.D.	Date: T.B.D.	Marketing Approved By: T.B.D.	Date: T.B.D.	QA Authorized By: T.B.D.	Date: T.B.D.
Production Approved By: T.B.D.	Date: T.B.D.	Global Service Approved By: T.B.D.	Date: T.B.D.	Created By: Peter Moree	Date: 18-02-2019
MNPD/MSE Approved By: T.B.D.	Date: T.B.D.	RA Approved By: T.B.D.	Date: T.B.D.	Page: 2 of 14	
				Template: DF 7.3/01/16, version 03	

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D.M.R. WORK INSTRUCTION			
Article number:	23610600		
Description:	MODULE MAYO ARM		
Revision:	E	Status:	Released




Step 2



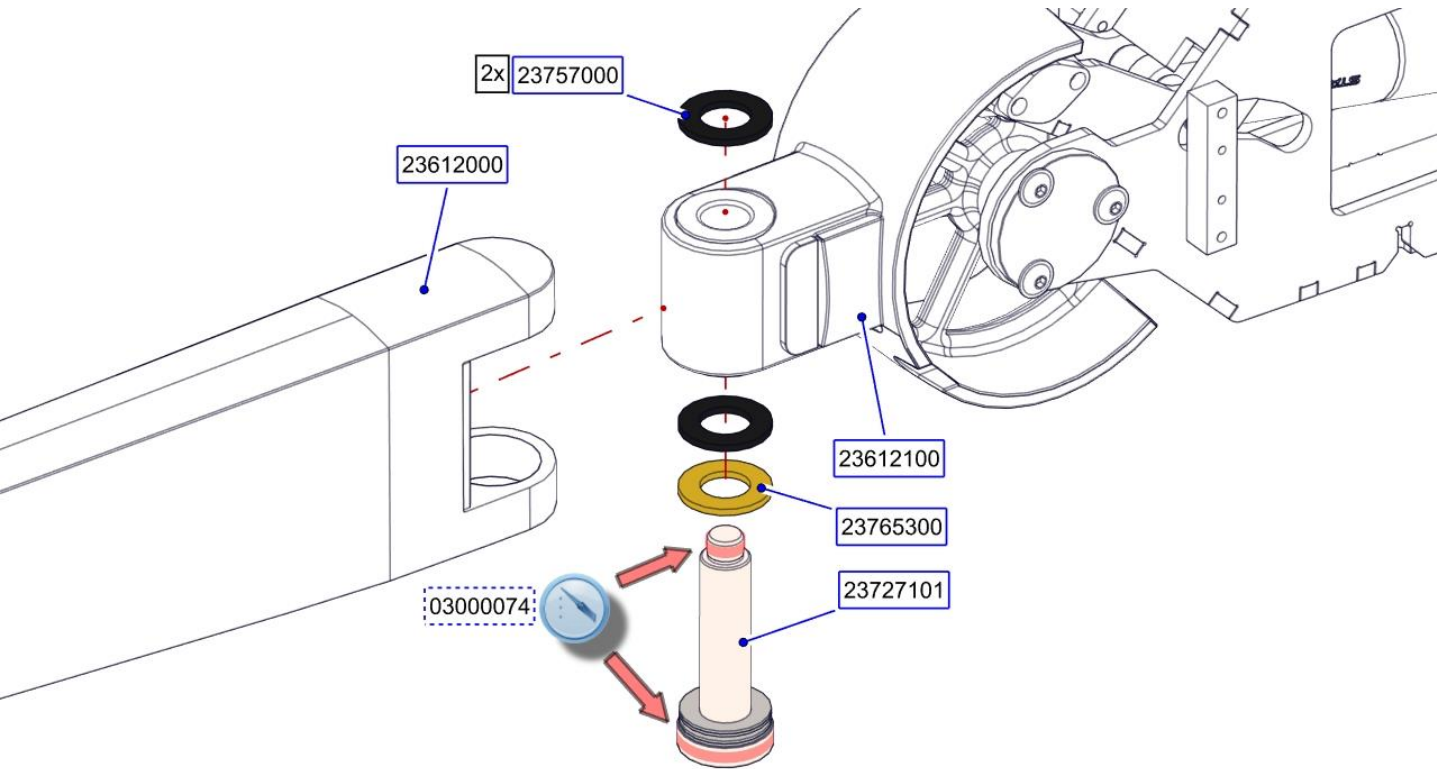
Part Number	Description	Qty	Length
09200974	MAYO DISC SPRING	4	
23727101	SPINDLE TABLE	1	

R&D Approved By: T.B.D.	Date: T.B.D.	Marketing Approved By: T.B.D.	Date: T.B.D.	QA Authorized By: T.B.D.	Date: T.B.D.
Production Approved By: T.B.D.	Date: T.B.D.	Global Service Approved By: T.B.D.	Date: T.B.D.	Created By: Peter Moree	Date: 18-02-2019
MNPD/MSE Approved By: T.B.D.	Date: T.B.D.	RA Approved By: T.B.D.	Date: T.B.D.	Page: 3 of 14	
				Template: DF 7.3/01/16, version 03	

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D.M.R. WORK INSTRUCTION				
Article number:	23610600			
Description:	MODULE MAYO ARM			
Revision:	E	Status:	Released	


Step 3



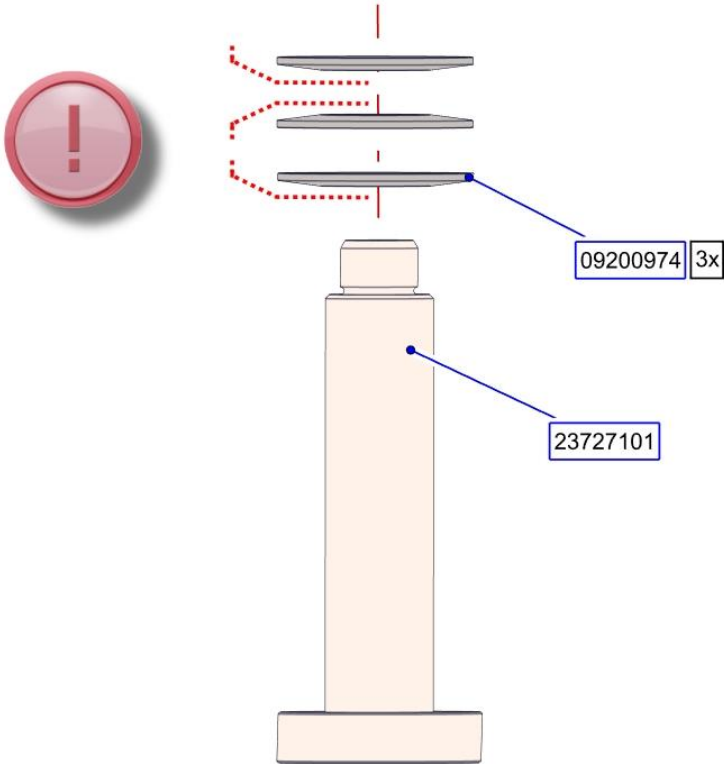
Part Number	Description	Qty	Length
03000074	LIJM LOCTITE 638	1	
23612000	SUBSAM MAYO FORE ARM	1	
23612100	SUBSAM ELBOW	1	
23727101	SPINDLE TABLE	1	

Part Number	Description	Qty	Length
23757000	RING MAYO ARM	2	
23765300	BRASS GLIDE RING	1	

R&D Approved By:	Date:	Marketing Approved By:	Date:	QA Authorized By:	Date:
T.B.D.	T.B.D.	T.B.D.	T.B.D.	T.B.D.	T.B.D.
Production Approved By:	Date:	Global Service Approved By:	Date:	Created By:	Date:
T.B.D.	T.B.D.	T.B.D.	T.B.D.	Peter Moree	18-02-2019
MNPD/MSE Approved By:	Date:	RA Approved By:	Date:	Page: 4 of 14	
T.B.D.	T.B.D.	T.B.D.	T.B.D.	Template: DF 7.3/01/16, version 03	


D.M.R. WORK INSTRUCTION				
Article number:	23610600			
Description:	MODULE MAYO ARM			
Revision:	E	Status:	Released	

Step 4

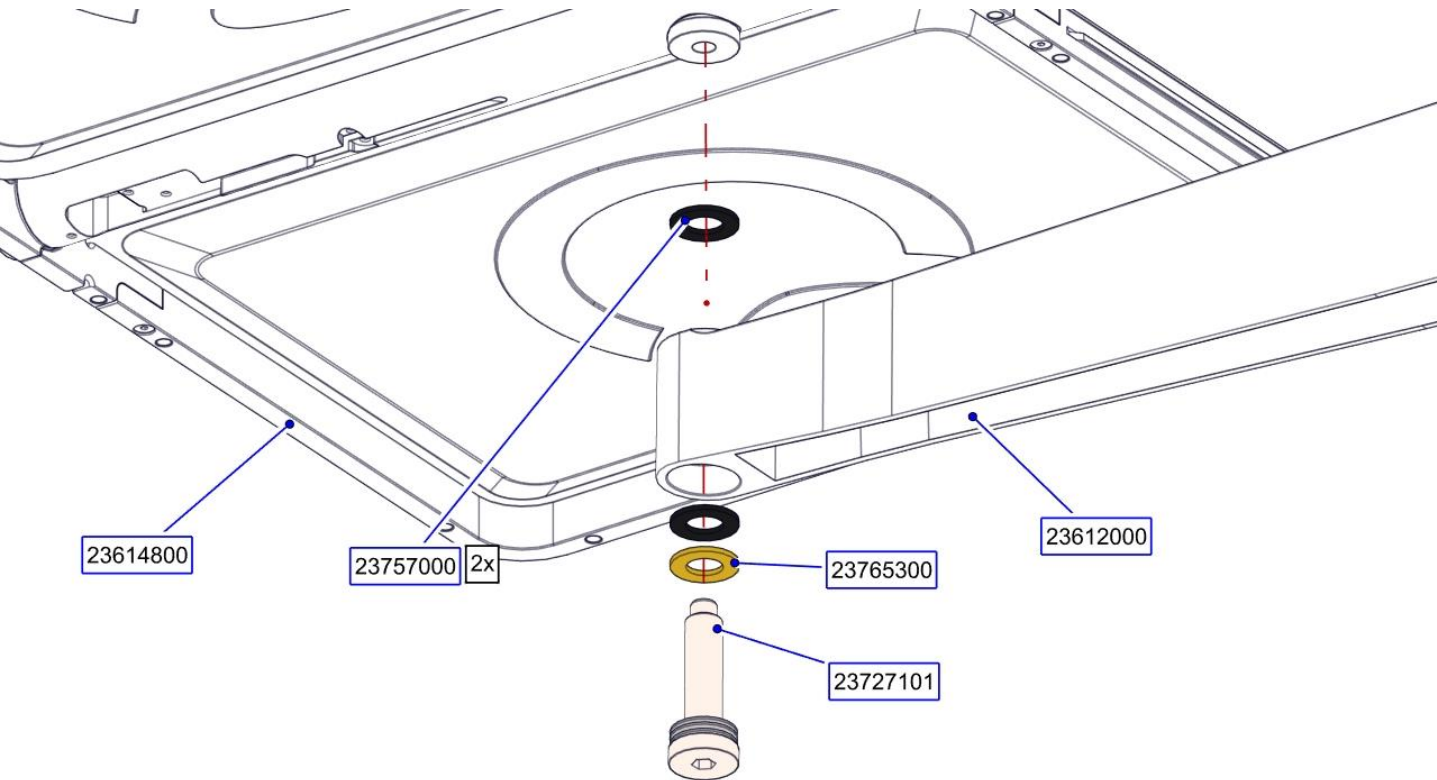


Part Number	Description	Qty	Length
09200974	MAYO DISC SPRING	3	
23727101	SPINDLE TABLE	1	

R&D Approved By:	Date:	Marketing Approved By:	Date:	QA Authorized By:	Date:
T.B.D.	T.B.D.	T.B.D.	T.B.D.	T.B.D.	T.B.D.
Production Approved By:	Date:	Global Service Approved By:	Date:	Created By:	Date:
T.B.D.	T.B.D.	T.B.D.	T.B.D.	Peter Moree	18-02-2019
MNPD/MSE Approved By:	Date:	RA Approved By:	Date:	Page: 5 of 14	
T.B.D.	T.B.D.	T.B.D.	T.B.D.	Template: DF 7.3/01/16, version 03	

D.M.R. WORK INSTRUCTION				
Article number:	23610600			
Description:	MODULE MAYO ARM			
Revision:	E	Status:	Released	


Stap 5



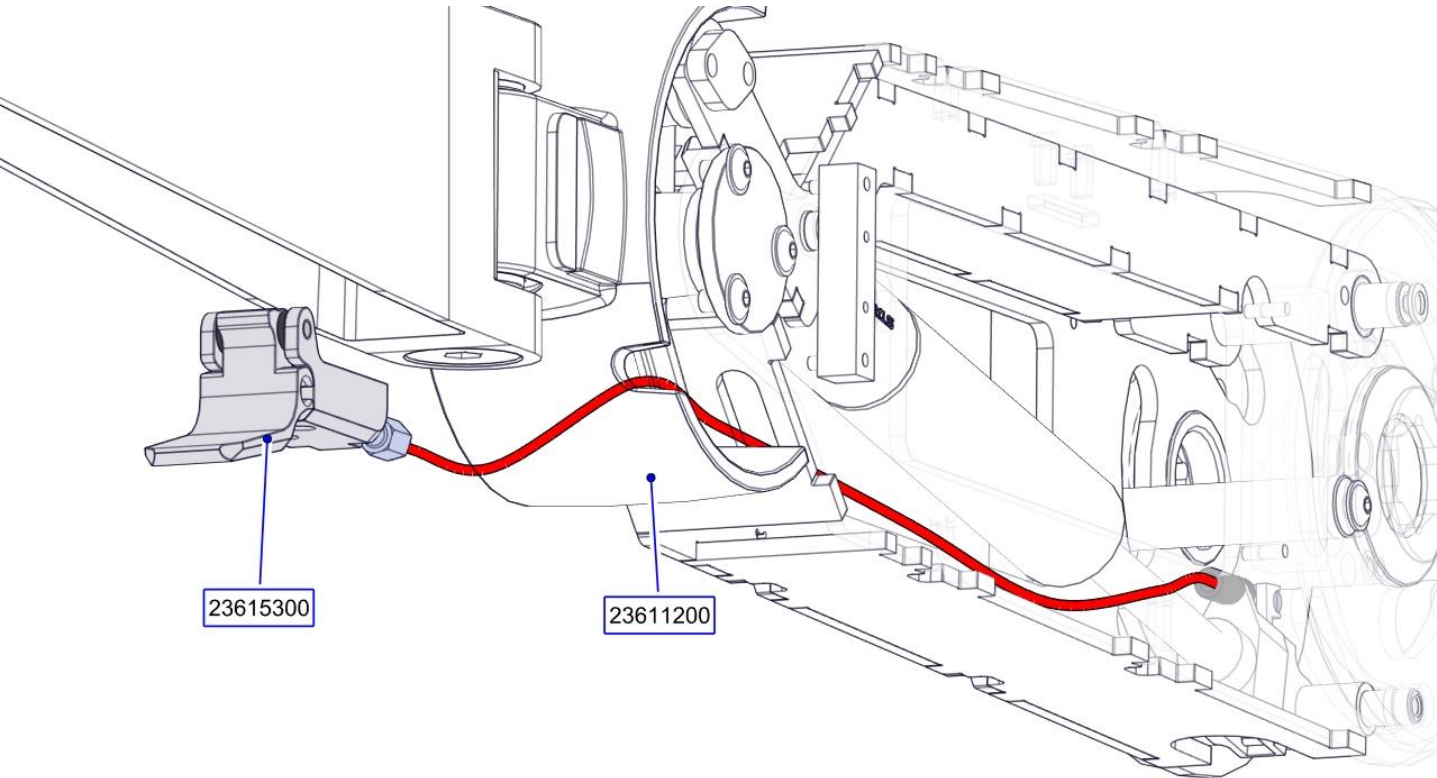
Part Number	Description	Qty	Length
23612000	SUBSAM MAYO FORE ARM	1	
23614800	SUBSAM MAYO TRAYS	1	
23727101	SPINDLE TABLE	1	

Part Number	Description	Qty	Length
23757000	RING MAYO ARM	2	
23765300	BRASS GLIDE RING	1	

R&D Approved By:	Date:	Marketing Approved By:	Date:	QA Authorized By:	Date:
T.B.D.	T.B.D.	T.B.D.	T.B.D.	T.B.D.	T.B.D.
Production Approved By:	Date:	Global Service Approved By:	Date:	Created By:	Date:
T.B.D.	T.B.D.	T.B.D.	T.B.D.	Peter Moree	18-02-2019
MNPD/MSE Approved By:	Date:	RA Approved By:	Date:	Page: 6 of 14	
T.B.D.	T.B.D.	T.B.D.	T.B.D.	Template: DF 7.3/01/16, version 03	

D.M.R. WORK INSTRUCTION				
Article number:	23610600			
Description:	MODULE MAYO ARM			
Revision:	E	Status:	Released	


Stap 6



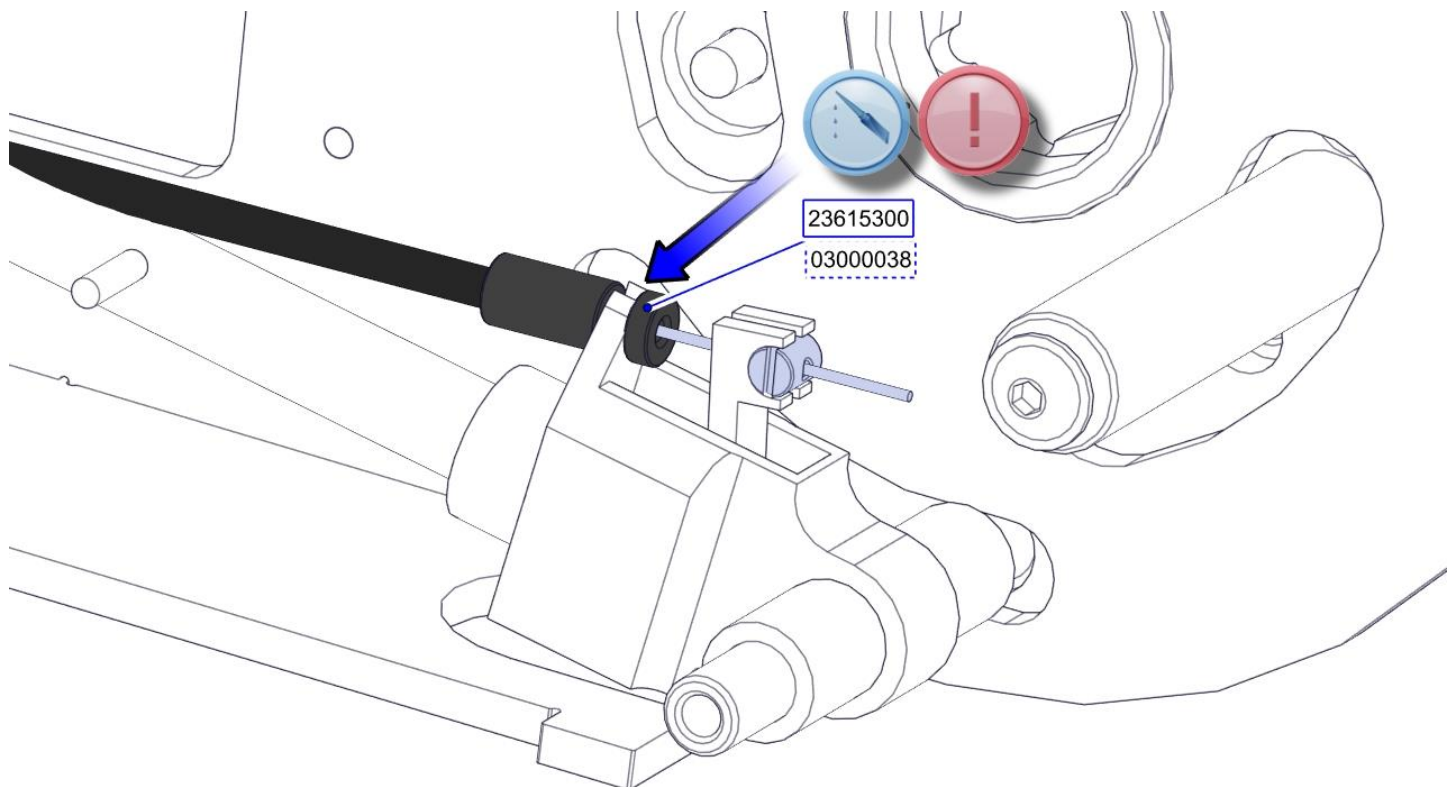
Part Number	Description	Qty	Length
23611200	SUBSAM MAYO BONE ARM	1	
23615300	MAYO HANDLE ASSEMBLY	1	

R&D Approved By:	Date:	Marketing Approved By:	Date:	QA Authorized By:	Date:
T.B.D.	T.B.D.	T.B.D.	T.B.D.	T.B.D.	T.B.D.
Production Approved By:	Date:	Global Service Approved By:	Date:	Created By:	Date:
T.B.D.	T.B.D.	T.B.D.	T.B.D.	Peter Moree	18-02-2019
MNPD/MSE Approved By:	Date:	RA Approved By:	Date:	Page: 7 of 14	
T.B.D.	T.B.D.	T.B.D.	T.B.D.	Template: DF 7.3/01/16, version 03	

D.M.R. WORK INSTRUCTION			
Article number:	23610600		
Description:	MODULE MAYO ARM		
Revision:	E	Status:	Released




Stap 7



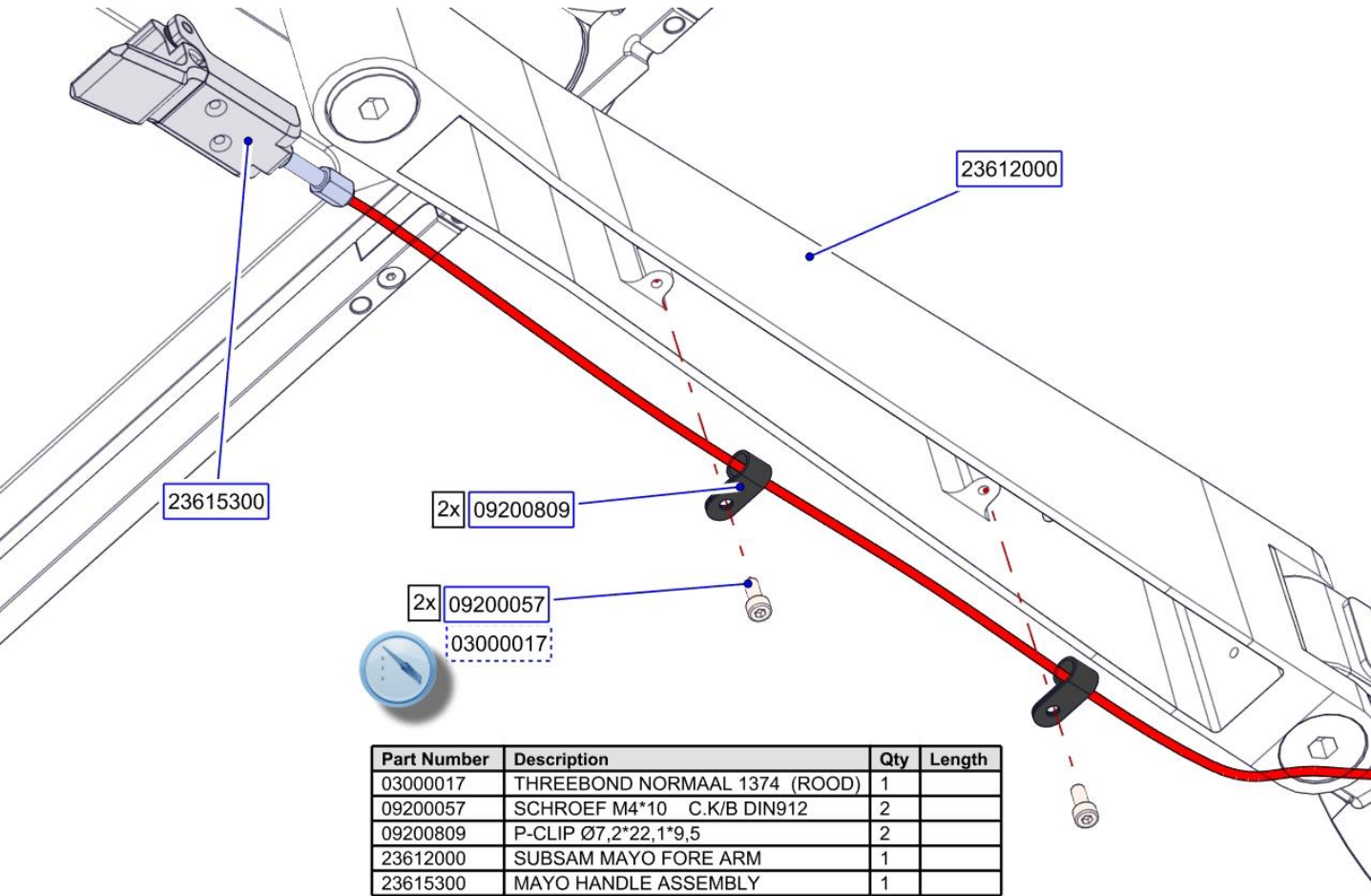
Part Number	Description	Qty	Length
03000038	LIJM ARA LDITE 2021 SOP 007	1	
23615300	MAYO HANDLE ASSEMBLY	1	

R&D Approved By: T.B.D.	Date: T.B.D.	Marketing Approved By: T.B.D.	Date: T.B.D.	QA Authorized By: T.B.D.	Date: T.B.D.
Production Approved By: T.B.D.	Date: T.B.D.	Global Service Approved By: T.B.D.	Date: T.B.D.	Created By: Peter Moree	Date: 18-02-2019
MNPD/MSE Approved By: T.B.D.	Date: T.B.D.	RA Approved By: T.B.D.	Date: T.B.D.	Page: 8 of 14	
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D.M.R. WORK INSTRUCTION				
Article number:	23610600			
Description:	MODULE MAYO ARM			
Revision:	E	Status:	Released	


Stap 8



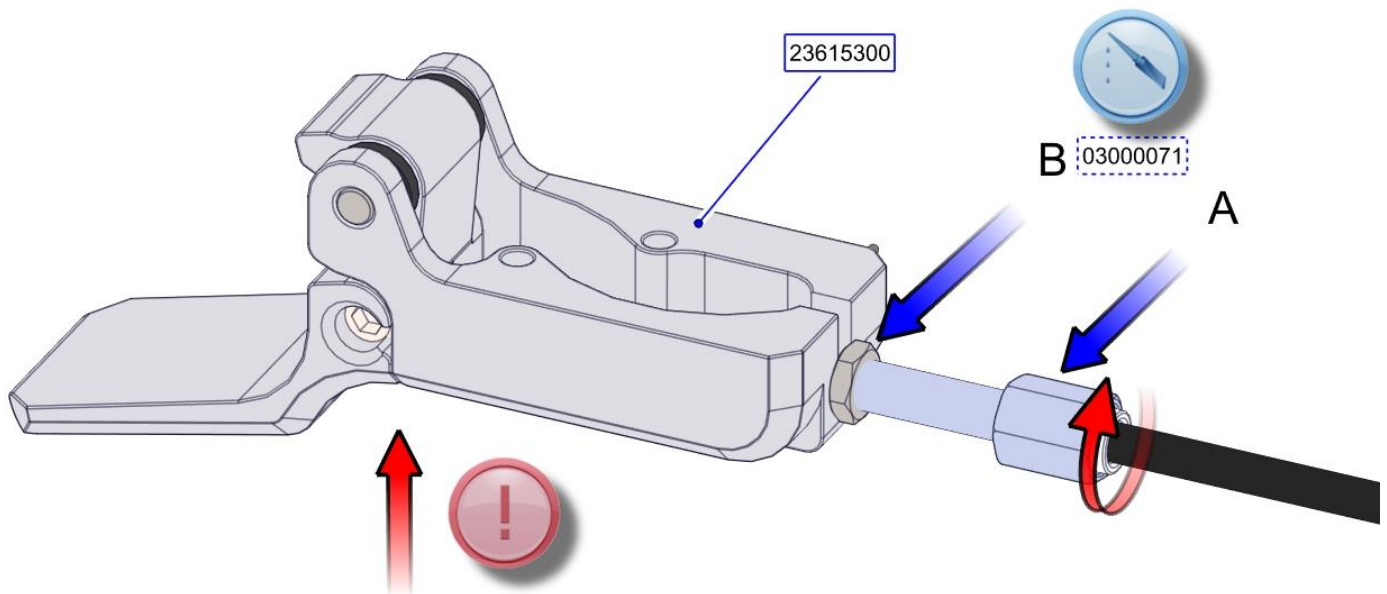
R&D Approved By:	Date:	Marketing Approved By:	Date:	QA Authorized By:	Date:
T.B.D.	T.B.D.	T.B.D.	T.B.D.	T.B.D.	T.B.D.
Production Approved By:	Date:	Global Service Approved By:	Date:	Created By:	Date:
T.B.D.	T.B.D.	T.B.D.	T.B.D.	Peter Moree	18-02-2019
MNPD/MSE Approved By:	Date:	RA Approved By:	Date:	Page: 9 of 14	
T.B.D.	T.B.D.	T.B.D.	T.B.D.	Template: DF 7.3/01/16, version 03	

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Description:	MODULE MAYO ARM		
Revision:	E	Status:	Released



Stap 9




Part Number	Description	Qty	Length
03000071	THREEBOND ZWAK 1344E (BLAUW)	1	
23615300	MAYO HANDLE ASSEMBLY	1	

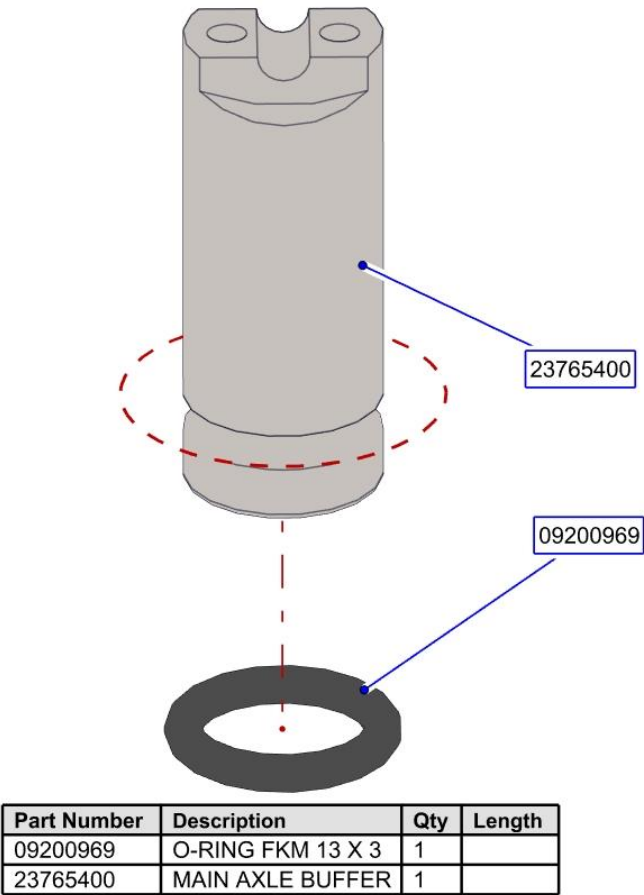
- Draai "A" aan tot er geen kier meer zit ter plaatse van de rode pijl.
- Gebruik "B" als contraemoer. Gebruik Threebond Blauw.

R&D Approved By:	Date:	Marketing Approved By:	Date:	QA Authorized By:	Date:
T.B.D.	T.B.D.	T.B.D.	T.B.D.	T.B.D.	T.B.D.
Production Approved By:	Date:	Global Service Approved By:	Date:	Created By:	Date:
T.B.D.	T.B.D.	T.B.D.	T.B.D.	Peter Moree	18-02-2019
MNPD/MSE Approved By:	Date:	RA Approved By:	Date:	Page: 10 of 14	
T.B.D.	T.B.D.	T.B.D.	T.B.D.	Template: DF 7.3/01/16, version 03	

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D.M.R. WORK INSTRUCTION				
Article number:	23610600			
Description:	MODULE MAYO ARM			
Revision:	E	Status:	Released	

Stap 10

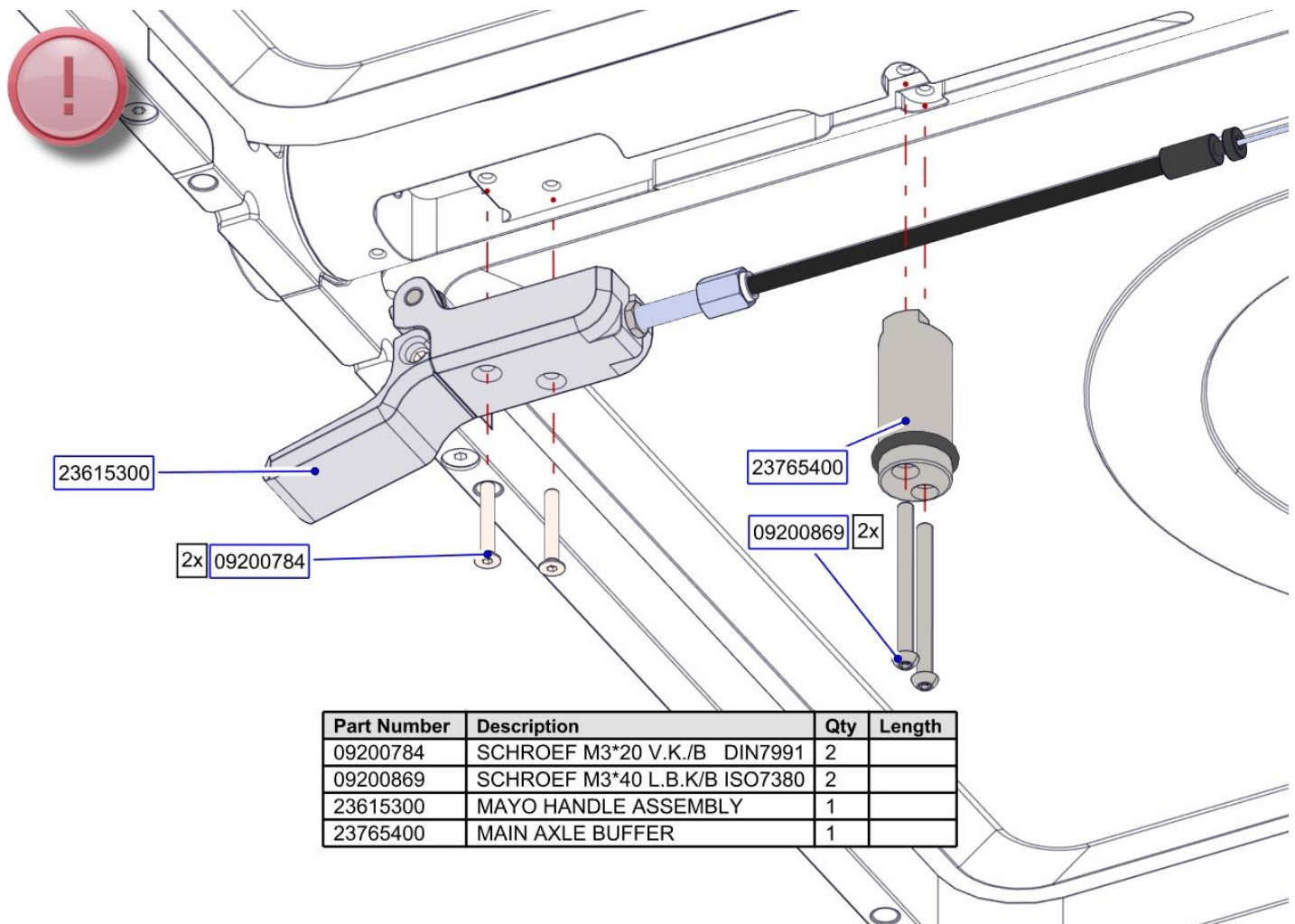


R&D Approved By:	Date:	Marketing Approved By:	Date:	QA Authorized By:	Date:
T.B.D.	T.B.D.	T.B.D.	T.B.D.	T.B.D.	T.B.D.
Production Approved By:	Date:	Global Service Approved By:	Date:	Created By:	Date:
T.B.D.	T.B.D.	T.B.D.	T.B.D.	Peter Moree	18-02-2019
MNPD/MSE Approved By:	Date:	RA Approved By:	Date:	Page: 11 of 14	
T.B.D.	T.B.D.	T.B.D.	T.B.D.	Template: DF 7.3/01/16, version 03	

D.M.R. WORK INSTRUCTION			
Article number:	23610600		
Description:	MODULE MAYO ARM		
Revision:	E	Status:	Released




Step 11



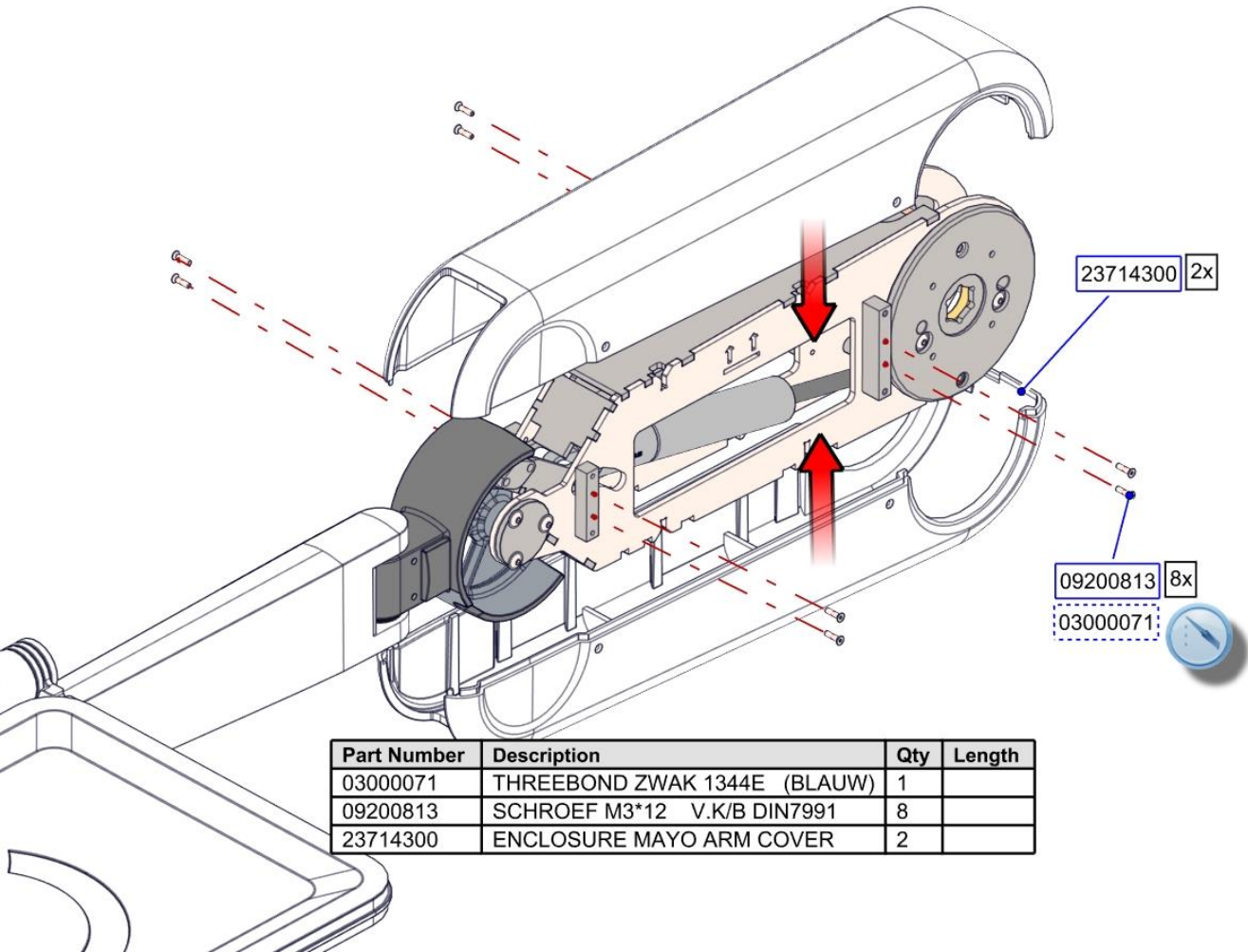
Part Number	Description	Qty	Length
09200784	SCHROEF M3*20 V.K./B DIN7991	2	
09200869	SCHROEF M3*40 L.B.K/B ISO7380	2	
23615300	MAYO HANDLE ASSEMBLY	1	
23765400	MAIN AXLE BUFFER	1	

R&D Approved By: T.B.D.	Date: T.B.D.	Marketing Approved By: T.B.D.	Date: T.B.D.	QA Authorized By: T.B.D.	Date: T.B.D.
Production Approved By: T.B.D.	Date: T.B.D.	Global Service Approved By: T.B.D.	Date: T.B.D.	Created By: Peter Moree	Date: 18-02-2019
MNPD/MSE Approved By: T.B.D.	Date: T.B.D.	RA Approved By: T.B.D.	Date: T.B.D.	Page: 12 of 14	
				Template: DF 7.3/01/16, version 03	

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D.M.R. WORK INSTRUCTION				
Article number:	23610600			
Description:	MODULE MAYO ARM			
Revision:	E	Status:	Released	


Step 12



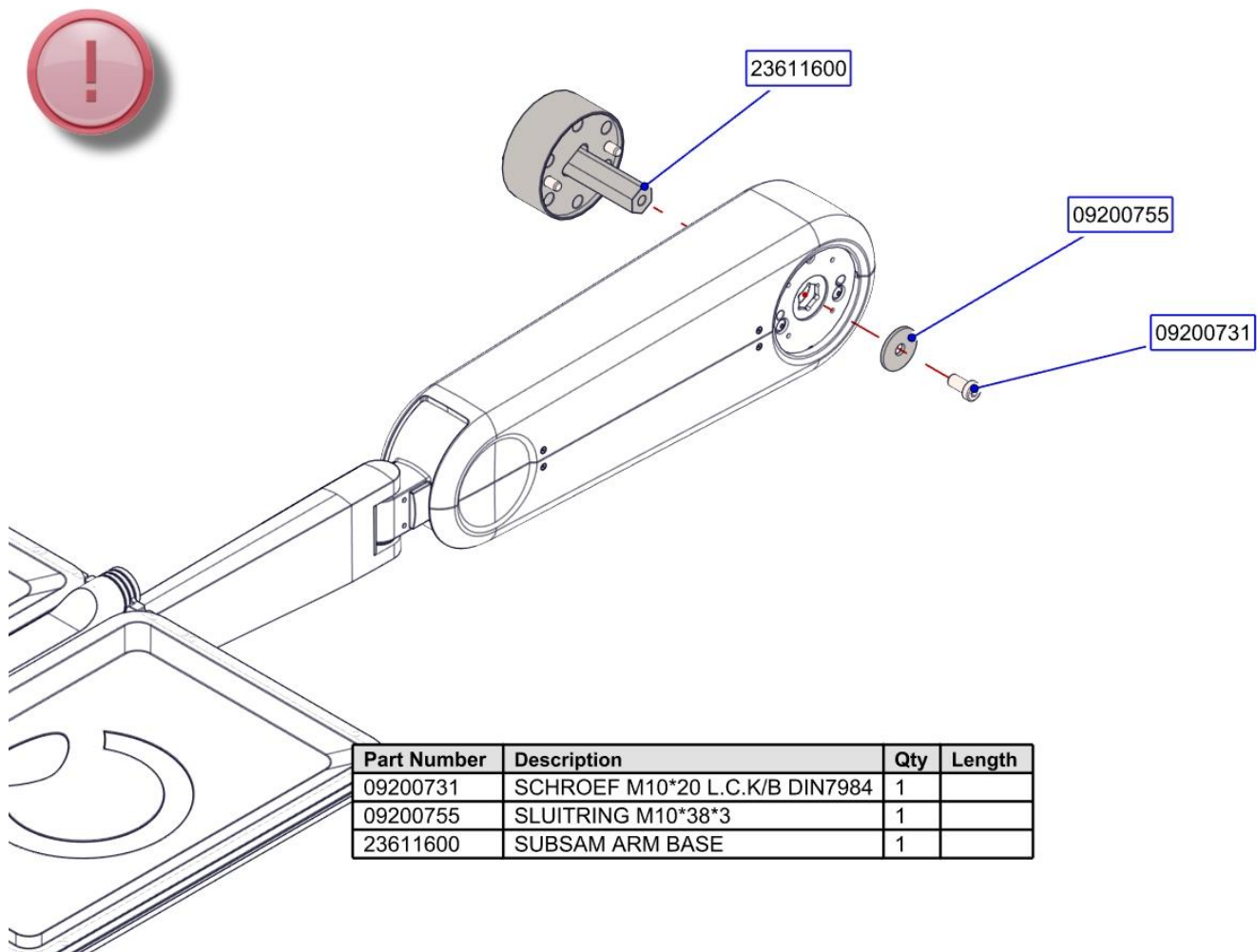
R&D Approved By:	Date:	Marketing Approved By:	Date:	QA Authorized By:	Date:
T.B.D.	T.B.D.	T.B.D.	T.B.D.	T.B.D.	T.B.D.
Production Approved By:	Date:	Global Service Approved By:	Date:	Created By:	Date:
T.B.D.	T.B.D.	T.B.D.	T.B.D.	Peter Moree	18-02-2019
MNPD/MSE Approved By:	Date:	RA Approved By:	Date:	Page: 13 of 14	
T.B.D.	T.B.D.	T.B.D.	T.B.D.	Template: DF 7.3/01/16, version 03	

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Article number:	23610600		
Description:	MODULE MAYO ARM		
Revision:	E	Status:	Released



Stap 13



R&D Approved By:	Date:	Marketing Approved By:	Date:	QA Authorized By:	Date:
T.B.D.	T.B.D.	T.B.D.	T.B.D.	T.B.D.	T.B.D.
Production Approved By:	Date:	Global Service Approved By:	Date:	Created By:	Date:
T.B.D.	T.B.D.	T.B.D.	T.B.D.	Peter Moree	18-02-2019
MNPD/MSE Approved By:	Date:	RA Approved By:	Date:	Page: 14 of 14	
T.B.D.	T.B.D.	T.B.D.	T.B.D.	Template: DF 7.3/01/16, version 03	

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